

Date: Tuesday, 12/20/2005 9:48:54 AM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: 206L BASKET LID	
Job Number	: 23136B		Part Number	: D2252043	
Estimate Number	: 11274		Drawing Number	: UNDER REVIEW	
P.O. Number	: N/A		Project Number	: N/A	
This Issue	: 12/20/2005 S.O. No. : N/A		Drawing Revision	: E	
Prsht Rev.	: NC		Material	: N/A	
First Issue	: N/A Type : LARGE FAB ASSY		Due Date	: 1/30/2006 Qty: 1 Um: Each	
Previous Run	: N/A				
Written By	: SEE COMMENT BELOW				
Checked & Approved By	: SEE COMMENT BELOW				
Comment	: Est Rev:l REVISED AS PER REV E 05-12-06 JLM				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M304TS0750W065	304 SQ Tube.75x.75x.065W	
		Comment: Qty.: 32.5539 f(s)/Unit Total : 32.5539 f(s) 3/4" x 3/4" x 0.063 wall 304/316 SS tubing. Batch: M19447	 <i>AA 06/01/17</i>
2.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1	
		Comment: LARGE FABRICATION RESOURCE 1	
		1- Cut D2252-1-3-9 as per Dwg D2252	
		2-Drill hole in D2252-1 as per Dwg D2252	 <i>AA 06/01/20</i>
		3-Deburr & Remove all Markings from Material	
3.0	D2329	Label Plate	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)	
		Pick: Qty Part Number Description Batch	
		1 D2329 Label Plate B11637	 <i>AA 06/01/20</i>
4.0	D23271	Spacer Bushing	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)	
		Pick: Qty Part Number Description Batch	
		1 D2327-1 Bushing B24873	 <i>AA 06/01/20</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Seq. #: Machine Or Operation:

Description :

5.0 D22321 Hinge



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	D2232-1	HINGE	B23445

M 06/01/20

6.0 D2581 Mounting Bracket



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	D2581	Mounting Chanel	A2539

M 06/01/20

7.0 M304EX07516F Expanded Metal Flat Stai



Comment: Qty.: 18.9000 sf(s)/Unit Total : 18.9000 sf(s)

Pick:

Qty	Part Number	Description	Batch
18 sf	M304EX0.75-16F	Expanded Metal	M19149

M 06/01/20

8.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld as per Dwg D2252 using Welding Table and corner Jig

Deburr as required

A/R SS ROD Batch: M19174

M 06/01/20

9.0 QC5/9 WELD INSPECTION



Comment: WELD INSPECTION

PD 06-01-20

10.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M 06 01 22

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 06/01/23
 QA: N/C Closed: _____ Date: _____

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Seq. #: Machine Or Operation:

Description :

11.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Job 01.22

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

12.0 PACKAGING 1

PACKAGING RESOURCE #1



Job 01.22

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GA

13.0 DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

545 06/01/20 ①

G 06/01/23

Job Completion



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